

Date: Monday, 6/12/2006 3:36:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB
 Job Number : 27503
 Estimate Number : 10498
 P.O. Number : N/A Part Number : D2739
 This Issue : 6/12/2006 S.O. No. : N/A Drawing Number : D2739 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C
 Previous Run : 27363 Material : N/A
 Written By : *SEA COMMENT Below* Due Date : 6/30/2006 Qty: 4 Um: Each
 Checked & Approved By : *060613*
 Comment : Est Rev: 02.11.28 Reformat KJ
 Est Rev: D 06-03-21 As Per Rev C JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web

B2440

Pm 06-07-10 (4)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg. D2739.

Pm 06-07-10 (4)

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

Pm 06-07-11 (4)

3-Use uni-bit to open holes to finish size as per Dwg D2739.

Pm 06-07-11 (4)

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

Pm 06-07-11 (4)

5-Deburr

Pm 06-07-11 (4)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP


DP

6-7-13

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:36:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 27503

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1 *IN 06-07-13*

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 6-7-13 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock
Location: *LG*

DP 6-7-13 (4)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.14

Job Completion



06.07.14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

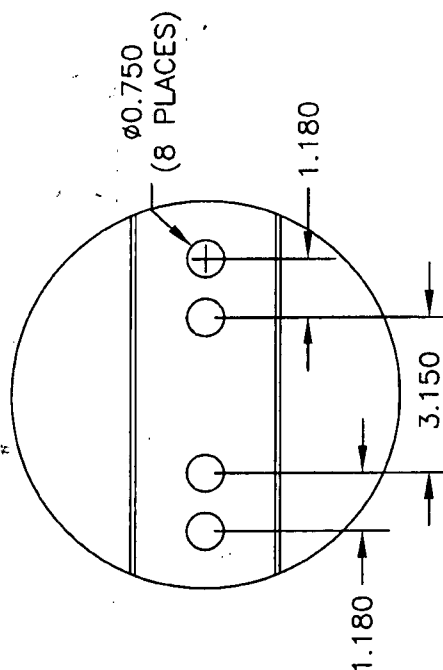
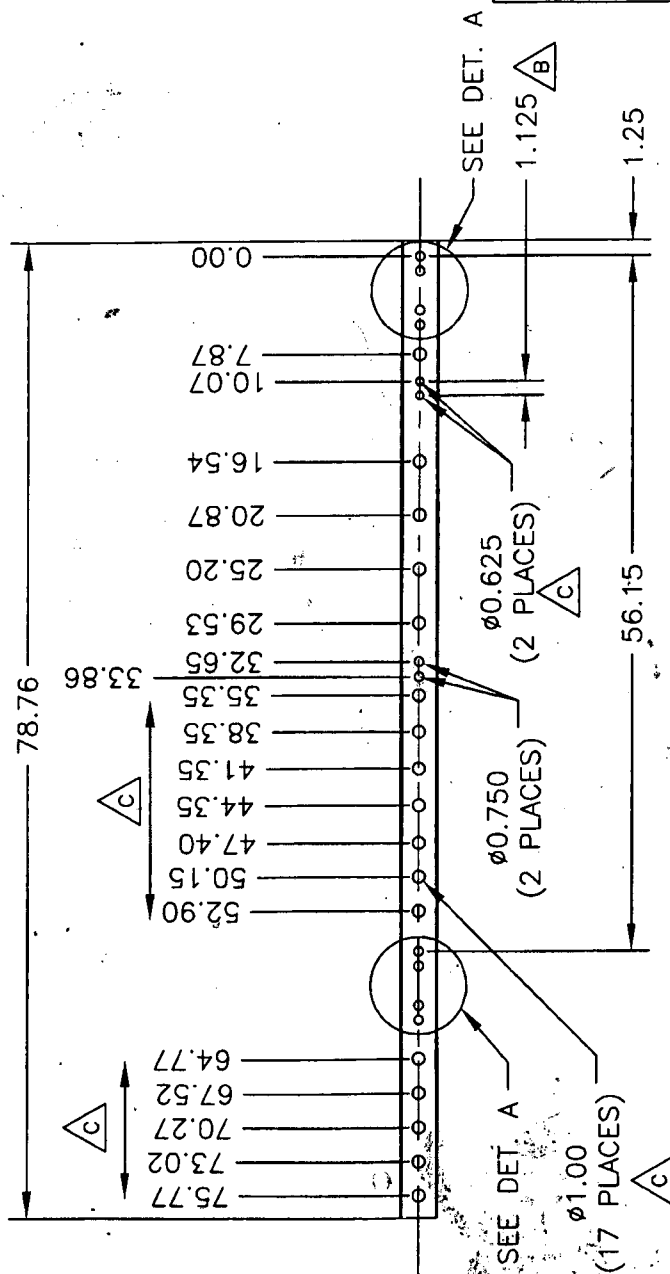
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DESIGN RH		DRAWN BY RH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D2739 REV. C SHEET 1 OF 1	
DATE 06.01.05		TITLE WEB		SCALE 1:15	
A	98.04.16	NEW ISSUE			
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS			
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS			

RELEASED
dc-0257



DETAIL A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27503

D2739 WEB

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1998 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.